

Amendments to the Claims:

The listing of claims will replace all prior versions, and listings, of claims in the application.

Listing of Claims:

Claims 1-12 (canceled)

Claim 13 (currently amended) A method of manufacturing a screw tight tube vice frame in a tattoo machine comprising the steps of:

- (a) Drilling an internal taper into a hollow rod and cutting threads onto the exterior surface of said rod;
- (b) Drilling a first hole into a tattoo machine frame but not completely through said frame, such that a portion of said frame remains;
- (c) Drilling a second hole of a smaller diameter than said first hole through the remaining portion of said frame using the same centerline as said first hole, such that there is a transverse hole in said frame;
- (d) Tapping said first hole;
- (e) Screwing said rod into said first hole such that said rod protrudes from said frame;
- (f) Machining a split ring ferrule with tapered ends of an angle equivalent to said internal taper of said rod;
- (g) Machining a nut adapted to screw onto said rod with said ferrule between said rod and said nut such that said ferrule ~~may be~~ is compressed by said nut to retain objects disposed within said ferrule.

Claims 14-35 (canceled)

Claim 36 (new) A method of manufacturing a screw tight tube vice frame in a tattoo machine comprising the steps of:

- (a) Drilling an internal taper into a hollow rod and cutting threads onto the exterior surface of said rod;
- (b) Drilling a first hole into a tattoo machine frame but not completely through said frame, such that a portion of said frame remains;

- (c) Drilling a second hole of a smaller diameter than said first hole through the remaining portion of said frame using the same centerline as said first hole, such that there is a transverse hole in said frame;
- (d) Tapping said first hole;
- (e) Screwing said rod into said first hole such that said rod protrudes from said frame;
- (f) Machining a split ring ferrule with tapered ends of an angle equivalent to said internal taper of said rod;
- (g) Machining a nut adapted to screw onto said rod with said ferrule between said rod and said nut such that said ferrule may be is not compressed by said nut to retain objects disposed within said ferrule.